

**Work Order ID 95535**

January-11-13 8:35:42 AM

**\*95535\***

Page 1

Item ID: D3890-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Panel, Side

Stop

**\*NS2\***

Start Date: 1/11/13 Start Qty: 3.00

**\*3\***

Cust Item ID:

Required Date: 1/25/13 Req'd Qty: 3.00

**\*3\***

Customer:

Reference:

Approvals: Process Plan: MLJDate: 13-01-11

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3890	A

100

0.00

**\*100\***

Waterjet

Memo

0.00

(4)

BB-1-27

FLOW CNC Waterjet

1-Cut as per Dwg D3890-1

Dwg Rev: AProg Rev: F

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

(4)

BB-1-27

NCR: Yes / No

# **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: Date:

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	General			Bend	General			Grain	Ovalized	Pressure/Forced	
Centre Not Concentric to O/S				BOM/Route				Hardware	Over/Under tolerance	Temperature/Cure	
Cracks				Broken/Damaged				Inspection Incomplete	Part Incorrect	Weld	
Crushed/Crimped.				Burrs				Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled	
Cuffs				Contamination				Maintenance	Part Moved		
Heat Treat				Countersink				Mislabeled	Positioned Wrong		
Inspection Strip in Tube				Cut Too Short				Misread	Power Loss/Surge		
Ripples in Bend				Drill Holes				Offset			
Torque Waves in Extrusion				Drawing				Out of Calibration			
Turning Sequence				Finish				Out of Sequence			
Wave/Twist in Tube				Folio				Outside Dimensions			



NCR: Yes / No

# **WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
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Part No. _____  NCR No. _____											
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending			Bend			Grain			Ovalized		
Centre Not Concentric to O/S			BOM/Route			Hardware			Over/Under tolerance		
Cracks			Broken/Damaged			Inspection Incomplete			Part Incorrect		
Crushed/Crimped.			Burrs			Instructions Incomplete/Unclear			Part Lost/Missing		
Cuffs			Contamination			Maintenance			Part Moved		
Heat Treat			Countersink			Mislabeled			Positioned Wrong		
Inspection Strip in Tube			Cut Too Short			Misread			Power Loss/Surge		
Ripples in Bend			Drill Holes			Offset			Other		
Torque Waves in Extrusion			Drawing			Out of Calibration					
Turning Sequence			Finish			Out of Sequence					
Wave/Twist in Tube			Folio			Outside Dimensions					

**Work Order ID 95535**

January-11-13 8:35:42 AM

**\*95535\***

Page 3

Item ID: D3890-041

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Panel, Side

Stop

**\*NS2\***

Start Date: 1/11/13 Start Qty: 3.00

**\*3\***

Cust Item ID:

Required Date: 1/25/13 Req'd Qty: 3.00

**\*3\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

**\*150\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

DAS  
15  
9-89  
B-1-31

160

**\*160\***

Packaging

Packaging

Pick Kit

0.00

Memo

0.00

170

**\*170\***

Small Fab

Small Fab

Memo

0.00

1- Bond gasket to smooth side of panel as per dwg  
A/R 3M 1300 adhesive Batch: 124297b  
A4 6 FF  
13-01-31

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____  NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	General			Bend	Grain	Ovalized	Pressure/Forced				
Centre Not Concentric to O/S				BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure				
Cracks				Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld				
Crushed/Crimped.				Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled				
Cuffs				Contamination	Maintenance	Part Moved					
Heat Treat				Countersink	Mislabeled	Positioned Wrong					
Inspection Strip in Tube				Cut Too Short	Misread	Power Loss/Surge					
Ripples in Bend				Drill Holes	Offset						
Torque Waves in Extrusion				Drawing	Out of Calibration						
Turning Sequence				Finish	Out of Sequence						
Wave/Twist in Tube				Folio	Outside Dimensions						

**Work Order ID 95535**

January-11-13 8:35:42 AM

**\*95535\***

Page 4

Item ID: D3890-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID: C

Item Name: Panel, Side

Stop **\*NS2\***

Start Date: 1/11/13

Start Qty: 3.00

**\*3\***

Cust Item ID:

Required Date: 1/25/13

Req'd Qty: 3.00

**\*3\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

**\*180\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

JMB

/

190

**\*190\***

Packaging

Packaging

Identify as per dwg &amp; Stock Location:

0.00

JMB

P/C 13/2/c (G)

200

**\*200\***

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

13/2/c (G)

PL 13-02-6

NCR: Yes / No

# **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: Date:

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**Picklist Print**

January-11-13 8:35:46 AM

Page 1

Work Order ID: 95535

**\*95535\***

Parent Item: D3890-041

**\*D3890-041\***

Parent Item Name: Panel, Side

Start Date: 1/11/13

Required Date: 1/25/13

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	335.0613	3.618	11.42526	16	B3-1-07	

**\*MI FXS 125-F60029-04\***

GE PLASTICS LEXAN SHEET

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT019	335.0613	
121803	335.0613	

D3890-3	Manufactured	No		160	Each	2.0000	2	6	121803	24	FF 13-01-31	
---------	--------------	----	--	-----	------	--------	---	---	--------	----	-------------	--

**\*D3890-3\***

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST416 95536 83934	2 2 2	8

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: Date:

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
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Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	General			Bend	Grain			Ovalized	Pressure/Forced		
Centre Not Concentric to O/S				BOM/Route	Hardware			Over/Under tolerance	Temperature/Cure		
Cracks				Broken/Damaged	Inspection Incomplete			Part Incorrect	Weld		
Crushed/Crimped.				Burrs	Instructions Incomplete/Unclear			Part Lost/Missing	Wrong Stock Pulled		
Cuffs				Contamination	Maintenance			Part Moved			
Heat Treat				Countersink	Mislabeled			Positioned Wrong			
Inspection Strip in Tube				Cut Too Short	Misread			Power Loss/Surge			
Ripples in Bend				Drill Holes	Offset						
Torque Waves in Extrusion				Drawing	Out of Calibration						
Turning Sequence				Finish	Out of Sequence						
Wave/Twist in Tube				Folio	Outside Dimensions						

DART AEROSPACE LTD	Work Order:	95535
Description: Panel	Part Number:	D3890-1
Inspection Dwg: D3890	Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

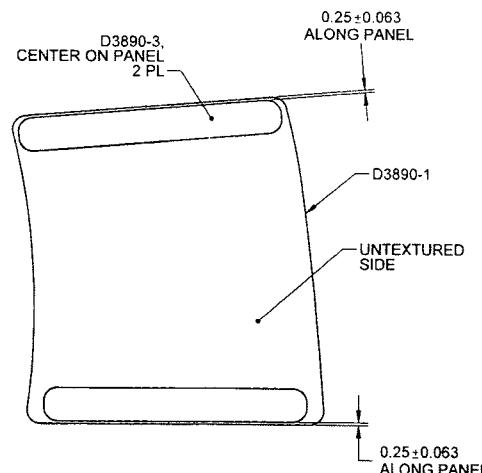
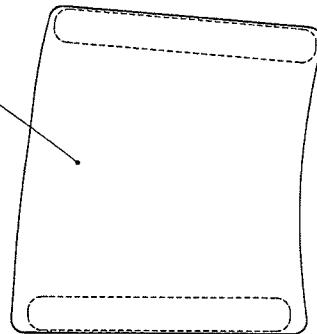
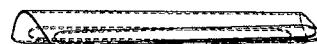
Measured by:	<u>B</u>	Audited by:	<u>JH</u>	Prototype Approval:	N/A
Date:	13-1-27	Date:	13/01/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue P/O D3890-041	KJ	M

8 7 6 5 4 3 2 1

## PARTS LIST

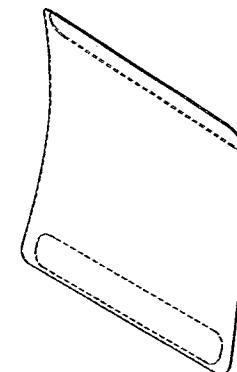
ITEM	QTY	P/N	DESCRIPTION
1	X	D3890-041	PANEL, SIDE
2	1	D3890-1	PANEL
3	2	D3890-3	GASKET
5	A/R	3M 1300	ADHESIVE

D3890-041 PANEL, SIDE

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3890-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.48 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE.

8 7 6 5 4 3 2 1



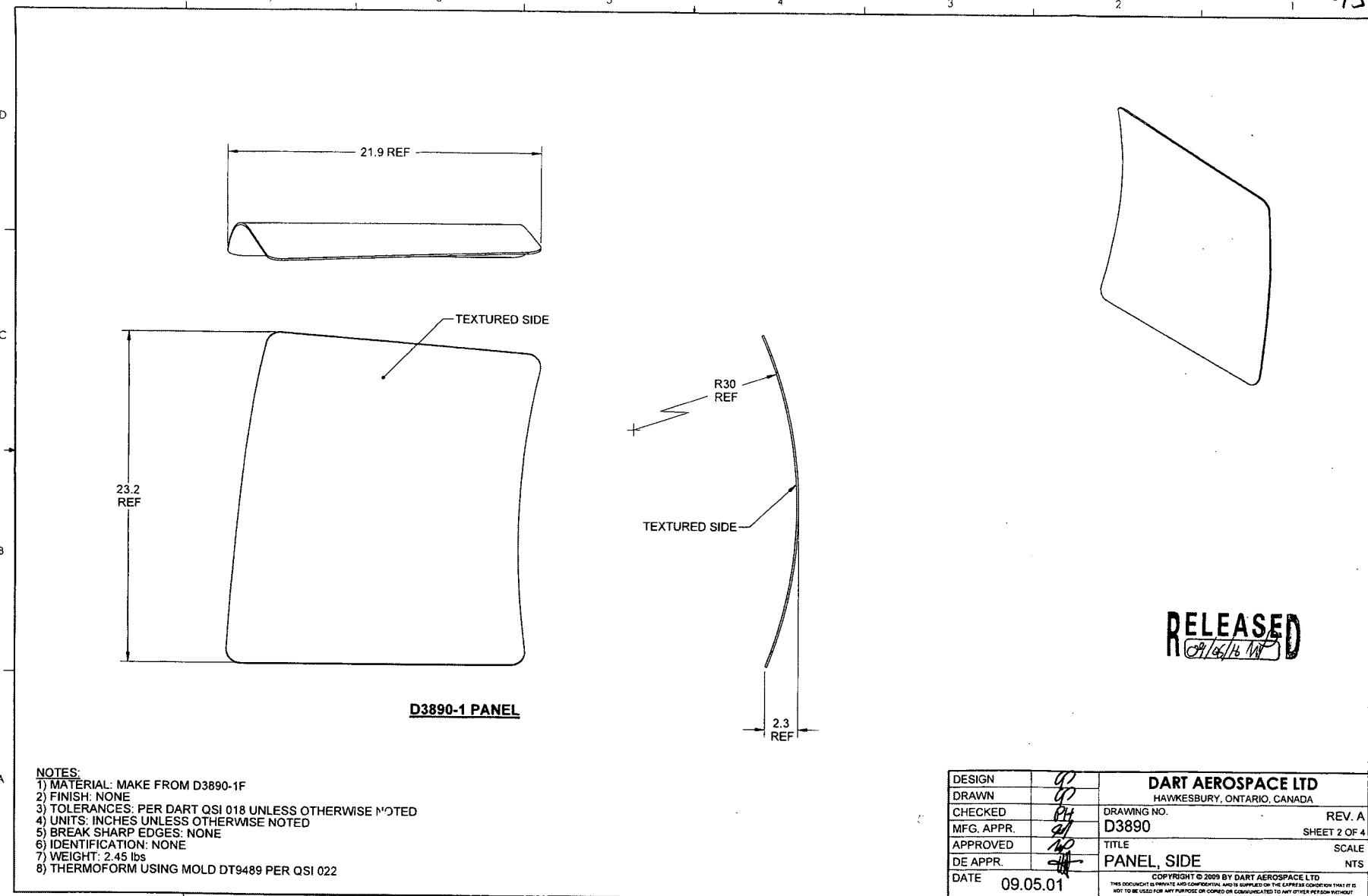
QTY: 1  
REV: A  
DATE: 09.05.01  
UNCONTROLLED  
SUBJECT TO CHANGE  
APRIL 2009  
W/C 2009  
NO. 05535 MJS  
13-01-11

RELEASED  
09.05.01 MJS

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKSLEY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	SH	D3890	SHEET 1 OF 4
APPROVED	SH	TITLE	SCALE
DE APPR.	SH	PANEL, SIDE	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD	

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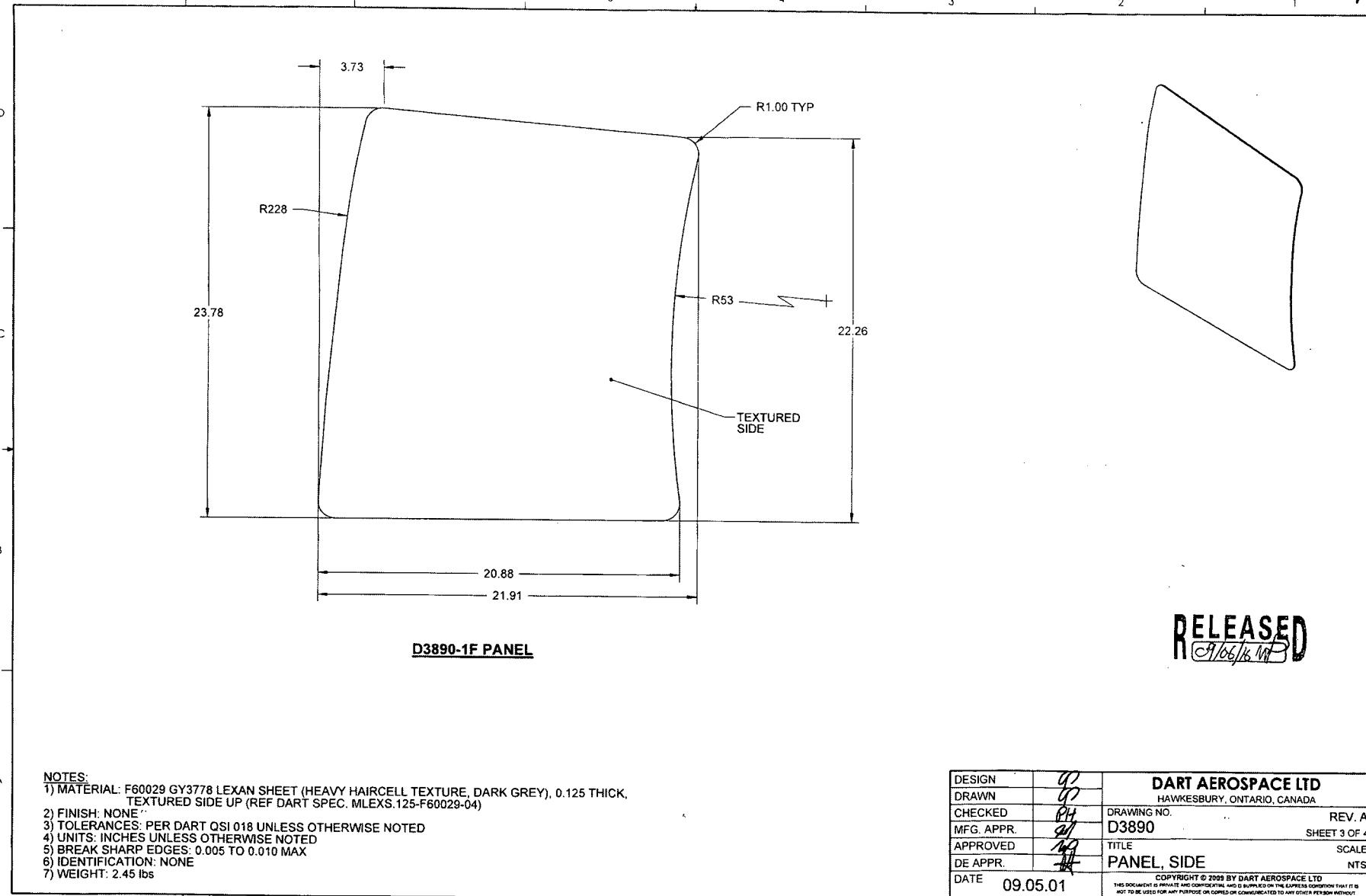
95535



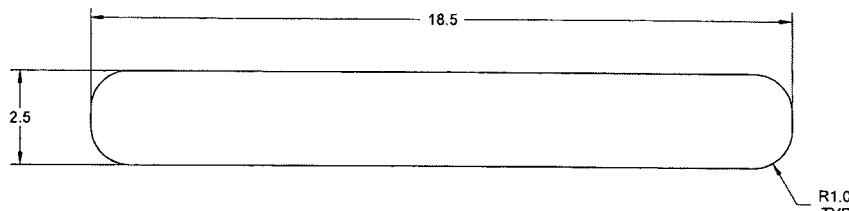
DESIGN	90	DART AEROSPACE LTD
DRAWN	90	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO.
MFG. APPR.	SH	REV. A
APPROVED	WJ	D3890
DE APPR.	CH	SHEET 2 OF 4
DATE	09.05.01	TITLE
		PANEL, SIDE
		SCALE
		NTS

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95535



95535

0.125  
REFD3890-3 GASKET

## NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK (REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES. NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	<i>g</i>	DART AEROSPACE LTD
DRAWN	<i>g</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	DRAWING NO.
MFG. APPR.	<i>g</i>	REV. A
APPROVED	<i>g</i>	SHEET 4 OF 4
DE APPR.	<i>g</i>	TITLE
DATE	09.05.01	SCALE
		NTS
		PANEL, SIDE

**RELEASED**  
*09/05/01 MP*

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